

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008597**Date Inspected:** 23-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Liu yang/ Mr. Xu le feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay no. 11

1.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 066478 perform SMAW welding on, Spare strut web to flange stiffener, Weld joint no. WD1-A 6001-1-57. ZPMC CWI Identified as Mrs. Yu dong ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2112

2.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040345 perform FCAW welding on, Interconnecting splice plate, Weld joint no. WSD1-SPSA3-56-1A. ZPMC CWI Identified as Mr. Zhan bo. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-TC-U5-F.

3.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 066881 perform FCAW welding on, Doubler plate, Skin E, Weld joint no. WSD1-FESA4-4 D/F-14. ZPMC CWI Identified as Mr. Xu le feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4332-TC-P4-F.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

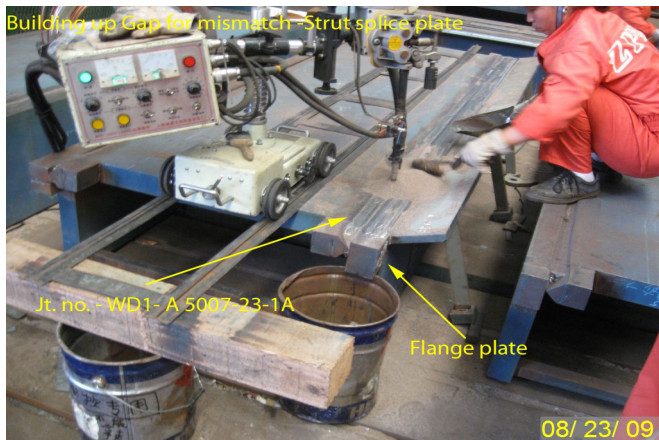
Bay no. 10

4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 051413 perform SAW welding on, Strut splice plate, Weld joint no. ED1-A 5007-25-1A. ZPMC CWI Identified as Mr. Ma yun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3221-TC-U5-S-1. Also, it is observed, the same welder is building up (Buttering) the flange plate by SAW. Photograph attached.

5.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 207745 perform SAW welding on, Skirt plates, Weld joint no. SSD1-A 681-2-147. ZPMC CWI Identified as Mr. Liu yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2C-2.

6.This QA inspector, Baskar Govindarajan, observed, Heat straightening of Strut splice plate, near weld joint no. WD1-A 5007-23-1A with hold down device (Jack) between two flanges. ZPMC CWI identified as Mrs. Yu dong ping and the QC identified as Mr. Mao bin bin. The Heat straightening report for the same found to be HSR 1 (T) -10148. Photograph attached.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge, Sinevod - 134-8257-0045, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Baskar, Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
